

5/28

DART AEROSPACE LTD	Work Order :	23690
Description: LUG BRACKET	Part Number:	D2735-1
Drawing: D2735 REV. B C/DM 99.08.09	Qty:	40 41

Step	Location	Procedure	By	Date	QTY
1	EXPEDITING	Issue Work Order	JA	05.06.27	40
2	PURCHASING	Issue P/O: <u>2008284</u> Make per Drawing D2735 Material release note required	LL	05-06-28	40
3	RECEIVING	Receive and Inspect for transit damage Ensure the material release note attached	DL	05/07/28	40
4	QC	Level 6 inspection per Master part Dwg and QSP 019	SB	05/08/24	41
5	METAL	Bend per Drawing D2735 Use CNC Brake Jig DT8204	SB	05/08/24	41
6	QC	Inspect Level 5	2	05-08-24	41
7	STORES	Identify and Stock	CPC	05-08-29	41
8	EXPEDITING	Close W/O Cost / part <u>7.63</u> <u>545</u> <u>05/08/30</u> <u>41</u> <u>7.76</u>	PA	05/08/30	41

Rev	Date	Change	Revised By	Approved
A	98.01.19	New Issue	BW	
B	98.11.16	Re-format, Changed steps	DM	PS

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Authorized Inspector

Date

RELEASED
DM 99.08.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 05-08-20

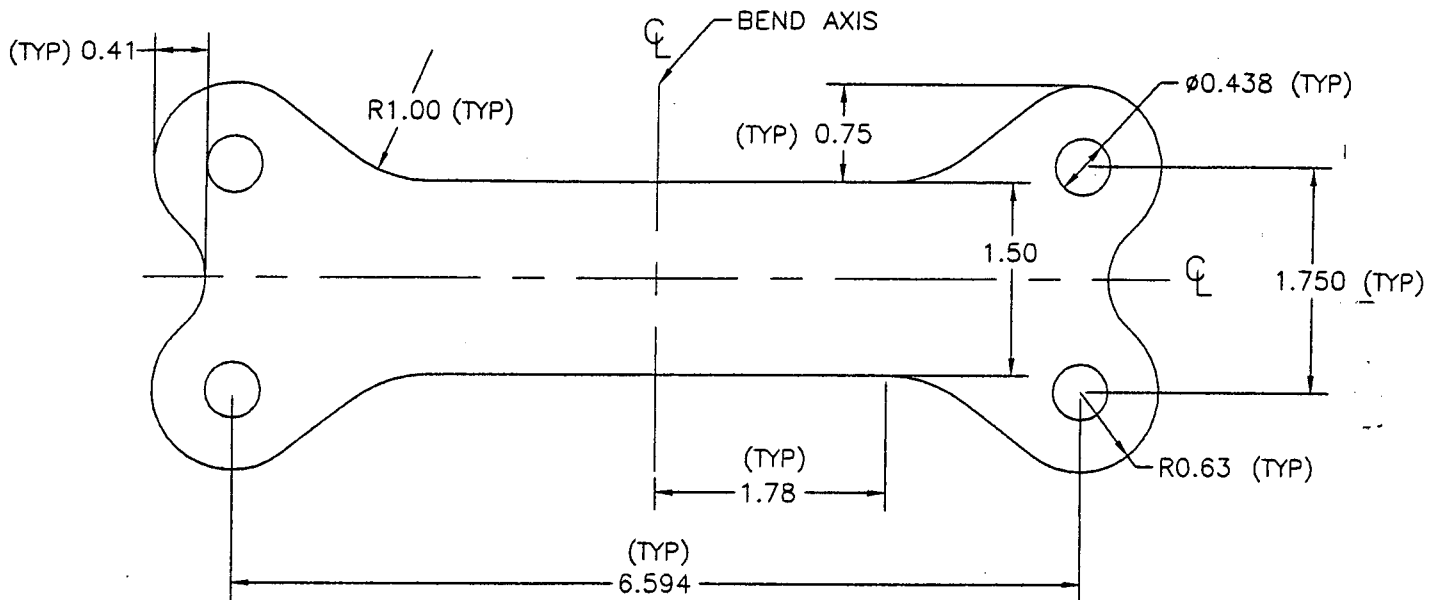
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

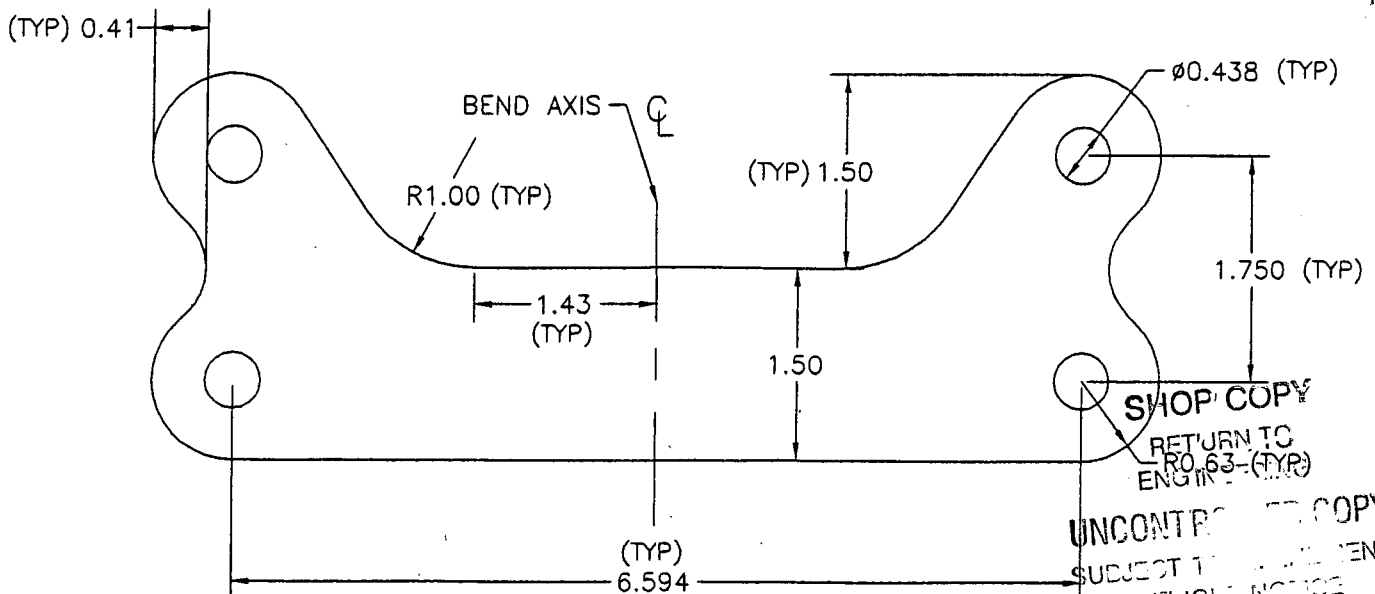


DESIGN <i>HL</i>	DRAWN BY <i>HL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (CL)

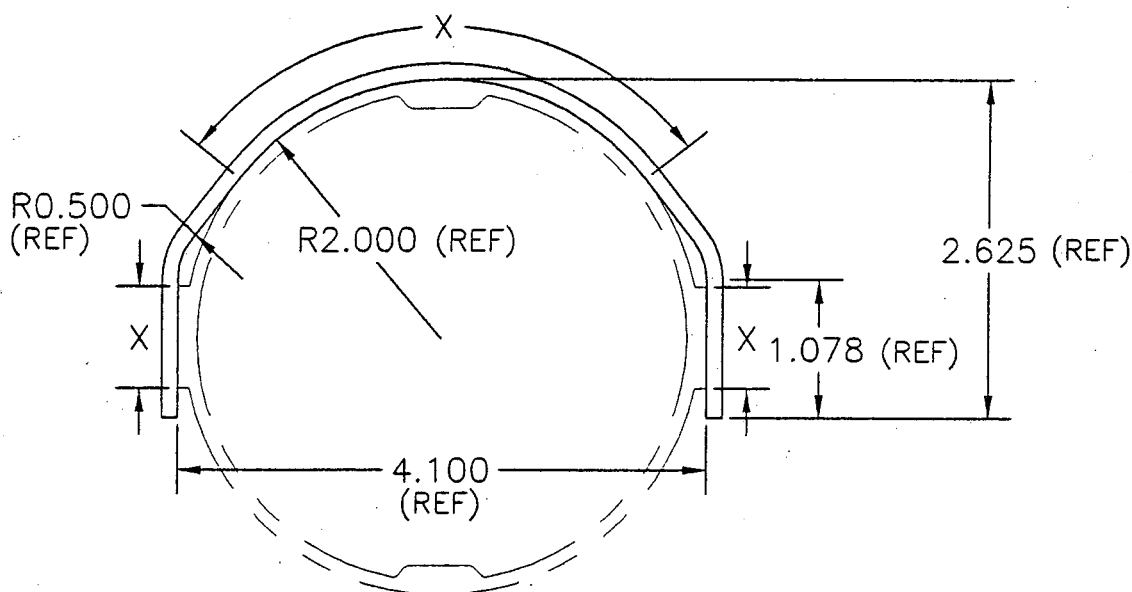
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WITHOUT NOTICE

WORK ORDER
NO. 23690



DESIGN <i>HA</i>	DRAWN BY <i>HA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

NO. 23690

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 27, 2005
08:10 am

Work Order No : 0023690
Project Name : D2735-1
Project For : WK528
Work Order Type : Main
Main WO Number :
House Part Number : D2735-1
Description : Lug Bracket
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 06-27-05
Est Finish Date : 07-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



燦茂實業股份有限公司

YIEH MAU CORP.

INVOICE NO. : F03MB57

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304, NO.4 (SIC)
FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE, AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.
SPECIFICATION : AISI 304

CUSTOMER :

INTEGRIS METALS LTD

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972885 FAX:(07)6973006
CERTIFICATE NO:9212243
DATE OF ISSUE:12/31/2003

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	H V	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
24GA/48"X120" (7425-8401)	1	1,442	3,179	YU129992	2AS68986C-1	281	687	56	81	157	4.6	50	110	26	4	804	1819	3.1
20GA/48"X120" (7426-2619)	1	1,446	3,188	YU226021	29S65042BA-21	293	636	58	81	157	4.4	55	115	31	4	808	1808	3.6
18GA/48"X120" (7426-5059)	1	1,428	3,148	YU226201	2AS68982B-21	303	672	56	83	165	4.2	52	115	23	2	814	1824	3.8
16GA/48"X96"	1	1,414	3,117	YU225206	2AS68037-21	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96"	1	1,412	3,113	YU225206	2AS68037-22	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96" (7426-5166)	1	1,413	3,115	YU225206	2AS68037-23	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-1	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-2	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120" (7426-5455)	1	1,215	2,679	YU225390	2AS67026B-3	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/60"X96" (7426-5497)	1	1,438	3,170	YU226508	2BS69861A-23	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X120" (7426-5612)	1	1,411	3,111	YU226508	2BS69861A-22	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X144" (7426-7949)	1	1,434	3,161	YU226508	2BS69861A-21	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
14GA/48"X96"	1	1,432	3,157	YU130016	2AS68134B-2	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X96" (7426-8053)	1	1,432	3,157	YU130016	2AS68134B-3	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X120"	1	1,435	3,164	YU225138	2AS68038B-1	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120"	1	1,437	3,168	YU225138	2AS68038B-2	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120" (7426-8160)	1	1,437	3,168	YU225138	2AS68038B-3	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X144" (7426-8244)	1	1,425	3,142	YU130016	2AS68134B-1	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/60"X96"	1	1,413	3,115	YU130125	2AS69265A-6	299	656	54	83	162	5	47	111	27	2	810	1808	3.6
19		26,834	59,158															

Remarks: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE CONTRACT.

Bend test: good for all Heat NO.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262E, ASME SA240, QQS766D.

YIEH MAU CORP.

Manager of Quality Assurance Section

16ga 304 2B SS

11GA K/O

PT KRAKATAU STEEL (PERSERO)

MILL CERTIFICATE

PURCHASER : MARUBENI-ITOCHU STEEL CANADA INC.,
METRO TOWER 11, SUITE 710, 4720 KINGWAY, BURNABY, B.C.,
V5H 4N2, CANADA
COMMODITY : HOT ROLLED COIL

LC. NO. : 104-LCI-906188
CERTIFICATE NO. : B F630207037630/MC/DN/1X/04
DATE : SEPTEMBER 01, 2004
LOT. NO. : 1
DELIVERY ORD. NO. : 0807
SUPPLIER ORD. NO. :
ORDER NUMBER : F630207

SPECIFICATION : ASTM A 1011 CB TYPE B

P40518ME005.

PAGE : 001 OF 001

HEAT NO.	SLAB NO.	COIL NO. AND PACKING NO.	TEST NO.	DIMENSION T X W X L (INCH)	QTY (N)	CHEMICAL COMPOSITION X100(X)						TENSILE TEST			IMPACT TEST	
						C	SI	MN	P	S	AL	YS	TS	EL	TEST	AVG
52731P	1900	129317B	20202510	104"NDMX48"XC	1	113.9	1.4	28.5	1.0	1.0	4.1	312	391	40	1800D	
54878P	5500	129325B	20202310	104"NDMX48"XC	1	113.1	1.0	31.4	1.7	1.3	3.9	327	409	40	1800D	
	1400	129453B	2020281	"	1	"	"	"	"	"	"	314	415	38	"	
54880P	1100	129350A	20202110	104"NDMX48"XC	1	113.6	1.3	26.7	0.9	1.3	4.2	319	406	38	1800D	
52728P	3109	129352A	20201810	119"NDMX48"XC	1	115.0	2.0	32.8	1.4	0.6	4.5	336	433	40	1800D	
		129352B	"	"	1	"	"	"	"	"	"	"	"	"	"	
52744P	3109	129353B	20201910	119"NDMX48"XC	1	113.9	0.8	30.2	1.2	1.5	4.4	329	413	36	1800D	
52728P	1200	129341A	20201810	119"NDMX48"XC	1	115.0	2.0	32.8	1.4	0.6	4.5	336	433	40	1800D	
		129341B	"	"	1	"	"	"	"	"	"	"	"	"	"	
54883P	1300	129372A	20200910	134"NDMX48"XC	1	114.8	1.0	27.1	0.9	0.9	3.8	324	413	40	1800D	
		129372B	"	"	1	"	"	"	"	"	"	"	"	"	"	
54878P	1800	129396B	20201610	134"NDMX48"XC	1	119.1	1.0	31.4	1.7	1.3	3.9	317	411	36	1800D	
52728P	1400	129431A	20201810	134"NDMX48"XC	1	115.0	2.0	32.8	1.4	0.6	4.5	336	433	40	1800D	
52684P	1400	129208A	20031010	188"NDMX48"XC	1	113.9	1.4	32.7	0.5	1.3	3.4	306	403	42	1800D	
		129208B	"	"	1	"	"	"	"	"	"	"	"	"	"	
52727P	1100	129115B	20131910	188"NDMX48"XC	1	115.0	1.7	25.1	1.4	1.0	4.3	323	428	42	1800D	
54882P	1400	129377A	20162410	188"NDMX48"XC	1	113.0	1.3	25.4	0.8	1.0	4.2	301	378	38	1800D	

RS/HS04/023, ISSUE NO : 03
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED ABOVE HAS BEEN TESTED
AND COMPLIES WITH THE TERMS OF THE ORDER CONTRACT

DIVISION OF QUALITY CONTROL



ACHMAD SAFI
SUPERINTENDENT

PHONE : (0254) 371015

Wed Jun 29 10:19:16 2005

From WILKINSON VAN



New Zealand Steel Limited
 Genbrock, South Auckland
 Postal: Private Bag 92121, Auckland, New Zealand
 Telephone: (09) 375 8899 / 375 8111 Auckland
 (06) 235 6088 / 235 9696 Waikato
 Fax: (09) 375 9999

TEST CERTIFICATE

Ref: 47172000

CUSTOMER	Wilkinson	P41006ME003	SPECIFICATION	ASTMA1011 CS Type B	CERTIFICATE No	TC101993
CUSTOMER Q/N	90-31N-294		PRODUCT	HOT ROLLED PICKLED & OILED	PAGE	1 of 1
MILL Q/N	453758		DIMENSIONS	0.104" x 48" x Coil 12 GAMS.	DATE	29 December 2004

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)							
		C	S	Mn	P	S	Cr	Ni	Al	Mo	V	Nb	Ti	A	B	N2	CEI	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS	r ()	LENGTH /ft
		x100			x100										x1000		x100							
HP-942195-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1					Good						955
HP-942196-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1					Good						955
HP-942197-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942198-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942200-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1					Good						955
HP-942201-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942202-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942203-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942204-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						889
HP-942205-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942206-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						951

YIELD	GAUGE LENGTH (G.L.)		PLASTIC STRAIN RATIO (r)		IMPACT TEST		CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=0	(C)=A5	(D)=5mm x 5mm	(A)=C+Mn/6	(C)=C+Mn/8+Si/24
(B)=LOWER YIELD STRESS	(B)=60mm	(D)=5.65 x So	(F)=8"	(B)=r90	(D)=(0.0025+2r45)/4	(E)=7.5mm x 10mm	(B)=C+Mn/6+(Cr+V+Ni)/15+(Cu+Ni)/15	(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
 QC/ASTALLURGIST